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D5489-045
Job Sheet 197745



Part No: D5489-045

Job Qty: 8 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/27/19

Created By: Manon Dubois

Type: Stock

Description:

Note: D5489 REV.B IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS REV:B 18.05.06 PRELIM B7 DD
VERF:JFS IPP REV:C 18.08.15 AS PER DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		8/27/19	0.17	2.67	Waterjet - Flow		08/19/09/09
110	QC 2	8 pcs		8/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		08/19/09/09
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

PRIORITY

120 QC 8	8 pcs	8/27/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	8 pcs	8/27/19	0.25 0.40	Small Fab - Brake - 1 - B4B	DAS 30 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	8 pcs	8/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Automated Welding - B4B	8 pcs	8/27/19	0.00 2.67	Automated Welding - 1 - B4B	MV
160 QC 10	8 pcs	8/27/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	

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170 QC 5	8 pcs	8/27/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	2
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	12
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Handfinish - 4-1-Assembly- B4B	8 pcs	8/27/19	0.00 2.67	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	AB 19-9-18
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
190 QC 3	8 pcs	8/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	SEP 19 2019
				QC 3 - 19	DAS 40
				QC 3 - 43	9-89
				QC 3 - 24	

				QC 3 - 61	
				QC 3 - 81	
200	Packaging 3-1 - Stock - B4B	8	8/27/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
210	QC 21 - SA	8	8/27/19	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
					QC 21 - SA - 53

Dc ST66

DAS

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SEP 19 2019

Part Op 100 - 1-Cut as per Dwg (D5489-5) Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - ***SEE NOTE 8,9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED

WELDING USE 8259 HARDCOAT BATCH: M139018

160 - (QC10- Inspect visual per QSI004- ground welds)

170 - QC5- Inspect part completeness to step on W/O)

180 - (Assemble as per dwg) COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 5213093

190 - (QC3- Inspect Part Finish)

200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP002

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	16 sf (2 ea)	100-Waterjet - Flow - 1	5200442

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	16	88	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD	Work Order:	197745
Description: Wear plate Assembly	Part Number:	DS489-015
Inspection Dwg: DS489 Rev: B		Page 1 of 1

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
.460	+/- .010	.458	1		Vibraz	
.620	+/- .010	.622	1		Tap	
.400	+/- .010	.398	1			
.500	+/- .010	.502	1			
2.44	+/- .030	2.44	1			
3.50	+/- .030	3.50	1			
5.92	+/- .030	5.92	1			
6.77	+/- .030	6.77	1			
7.58	+/- .030	7.58	1			
.93	+/- .030	.93	1			
7.84	+/- .030	7.84	1			
20.20	+/- .030	20.20	1			
28.37	+/- .030	28.37	1			
36.40	+/- .030	36.40	1			
38.07	+/- .030	38.07	1			
Manual Milling						
2.50	+/- .030	2.50	1			
15.50	+/- .030	15.50	1			
11.00	+/- .030	11.00	1			
.063	+/- .010	.058	1			

Measured by:	de	Audited by:		Preliminary Approval:	
Date:	19/09/09	Date:	DAS 61 9-89	Date:	
Rev	Date	Change	Revised by	Approved	
A	14.07.14	New Issue	KJ		